

Work Order ID 97779-1 *Select*

97779

Page 1

February-22-13 11:41:53 AM

Item ID: D3560-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Weldment

Start Date: 2/22/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 2/27/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: *W* Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3560	Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

on 13/02/22

8

φ

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA694 Rev: *AA* & Dwg D3560 Rev: *D*
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

D.A. MSP 13/02/24

8

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DAS 08 2-83

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

D.A. MSP 13/02/24

8

φ

DAS 08 2-83

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Page 2

Item ID: D3560-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Weldment
 Start Date: 2/22/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/27/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Large Fab	0.00							
140									
Large Fab	Memo	0.00							
Large Fab									

1-Weld assembly as per dwg D3560
 STEP:
 1- clean material (buff bracket and bottom of arm with blue pad)
 2- set up bracket and arm on jig
 3- preheat bracket and arm with torch
 4- clean before welding with brush
 5- set up machine to 135 amps
 6- weld across bottom and top ends
 7- reheat with torch (65 deg C)
 8- on one side weld from bottom to top half way
 9- same for other side (half way)
 10- from half way point weld the rest of the first side (ease off pedal near end)
 11- same for remaining side (ease off pedal near end)

13.04.29

Work Order ID 97779

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Page 3

Item ID: D3560-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Weldment
 Start Date: 2/22/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/27/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(8)	B-04-30		DAS 09 2-83
160 *160* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(8)	B-04-30		DAS 09 2-83
170 *170* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				8	φ Ae 13.05.02		

Work Order ID 97779

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Page 4

Item ID: D3560-042 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm Weldment
 Start Date: 2/22/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/27/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180 QC3- Inspect Part Finish 0.00

180

QC

Quality Control

Memo

0.00

190

190

Small Fab

Small Fab

Small Fab

Memo

1-Press bushing in D3560 arm per dwg D3562

0.00

0.00

200

200

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS 16

13/05/12

(x7)

ac

8x

7x

EP 3/05/12

EP 3/05/12

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Item ID: D3560-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm Weldment
 Start Date: 2/22/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/27/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>WAC03</u>	0.00							
210						8	φ		13-05-02
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL ***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									13/5/6 J
QC	Memo	0.00							
Quality Control									

13-05-3

Picklist Print

February-22-13 11:41:52 AM

Page 1

Work Order ID: 97779
Parent Item: D3560-042
Parent Item Name: Arm Weldment

Start Date: 2/22/13

Required Date: 2/27/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808 Bushing		Manufactured	No			100	Each	82.0000	1	4		2/23/05/02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		82							
				82018		42							
				85479		40							
D3592-1 Plate		Manufactured	No			190	Each	31.0000	1	4		11.3.04.29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002 397778		2							
				47015		2							
				WA003		29							
				80379		3							
				82022		8							
				82248		18							
M6061T6B0.500X05.000 6061-T6 Bar .500 x 5.00		Purchased	No			140	f	17.3500	1.395	5.8736842			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT001		13.16							
				119346		1.16							
				124681		12							
				MAT004		4.19							
				121040		4.19							
												11.08	OK 13/02/22

DART AEROSPACE LTD		Work Order: 97779
Description: Arm		Part Number: D3560-2
Inspection Dwg: D3560	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

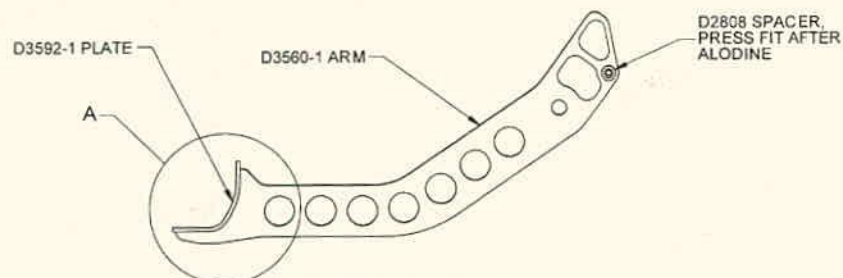
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	Ø0.5065	✓		Mic	GA-03
Ø0.196	+0.005/-0.001	Ø0.197	✓		Vern	GA-01
Ø1.000	+0.010/-0.001	Ø1.004	✓		"	"
0.500	+/-0.010	0.509	✓		"	"
0.250	+/-0.010	0.249	✓		"	"
0.275	+/-0.010	0.275	✓		"	"
0.188	+/-0.010	0.189	✓		"	"
2.000	+/-0.010	2.001	✓		"	"
1.700	+/-0.010	1.701	✓		"	"
Ø0.385 x 100°	+/-0.010 x 0.5°	0.380	✓		Mic	MJP-04
0.250 Deep	+/-0.010	0.248	✓		D-6	GA-10

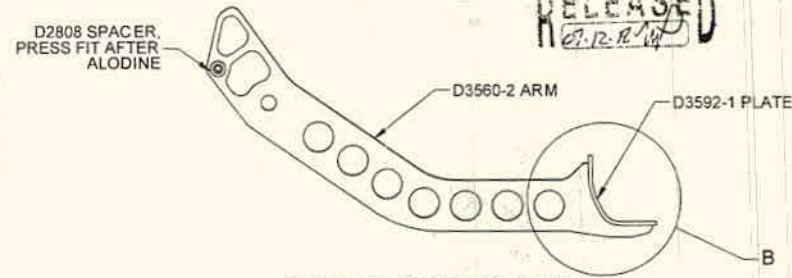
Measured by: D.A. 08	Audited by: [Signature]	Prototype Approval:	N/A
Date: 13/02/24	Date: 13/02/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-042	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	09.06.11	Dwg Rev updated	KJ [Signature]	[Signature]

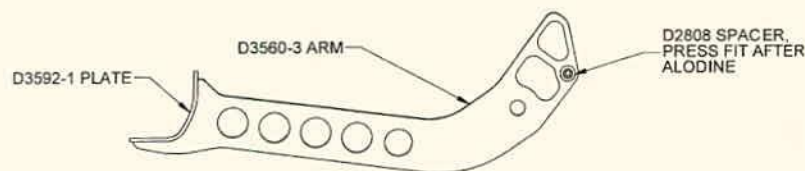
RELEASED
C.R.R.



D3560-041 ARM WELDMENT



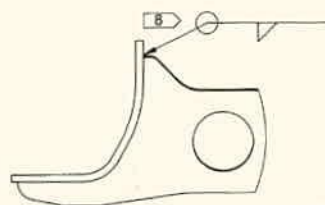
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1:2**

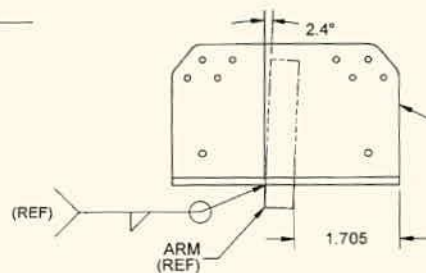
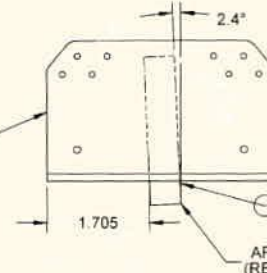
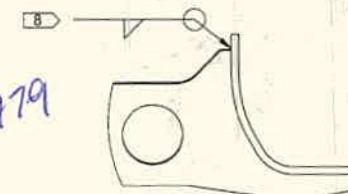


PLATE
(REF)



ARM
(REF)



**DETAIL B
SCALE 1:2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

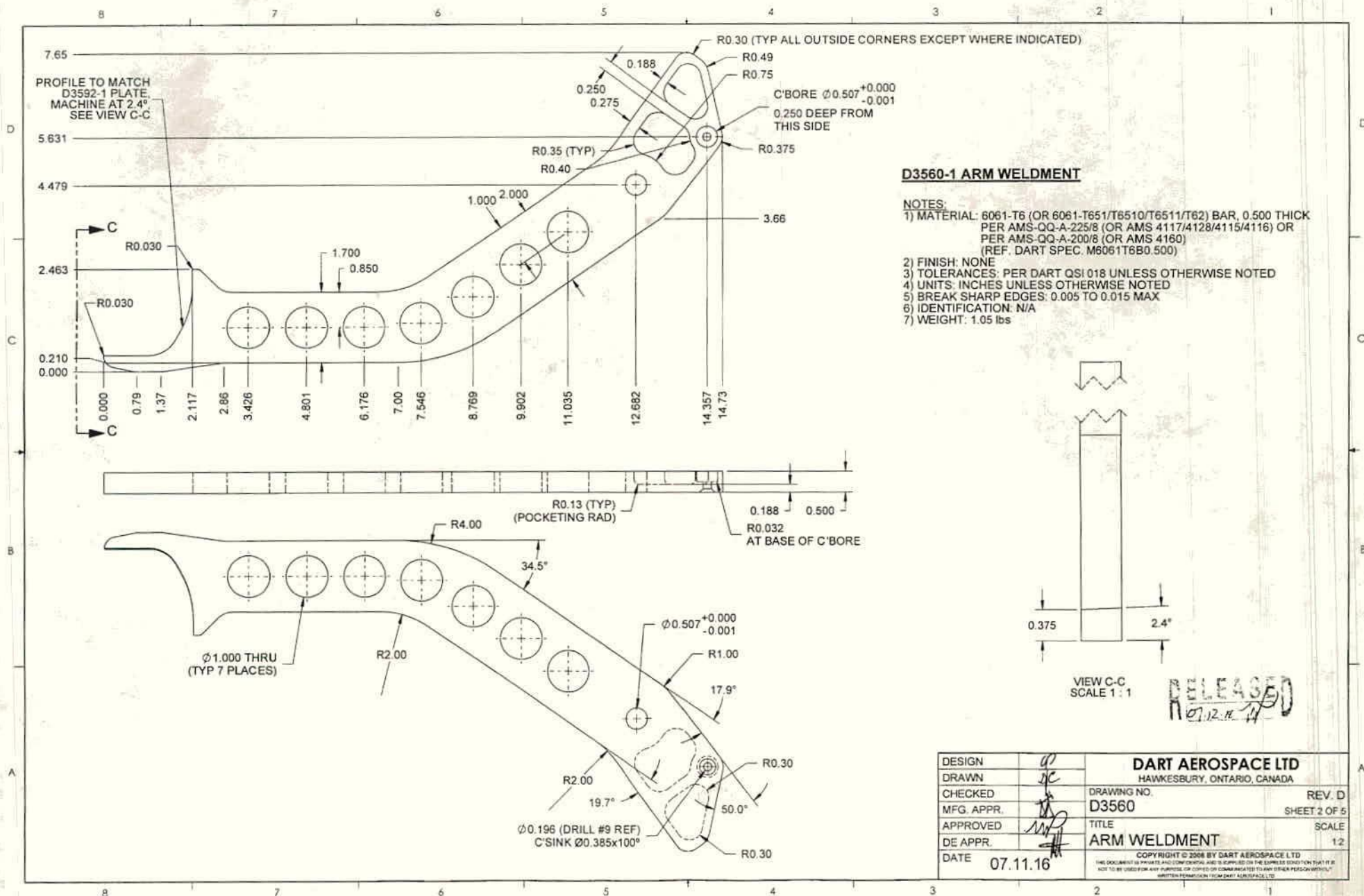
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.23 lbs (TYP)
 8) WELDING: PER DART QSI 004

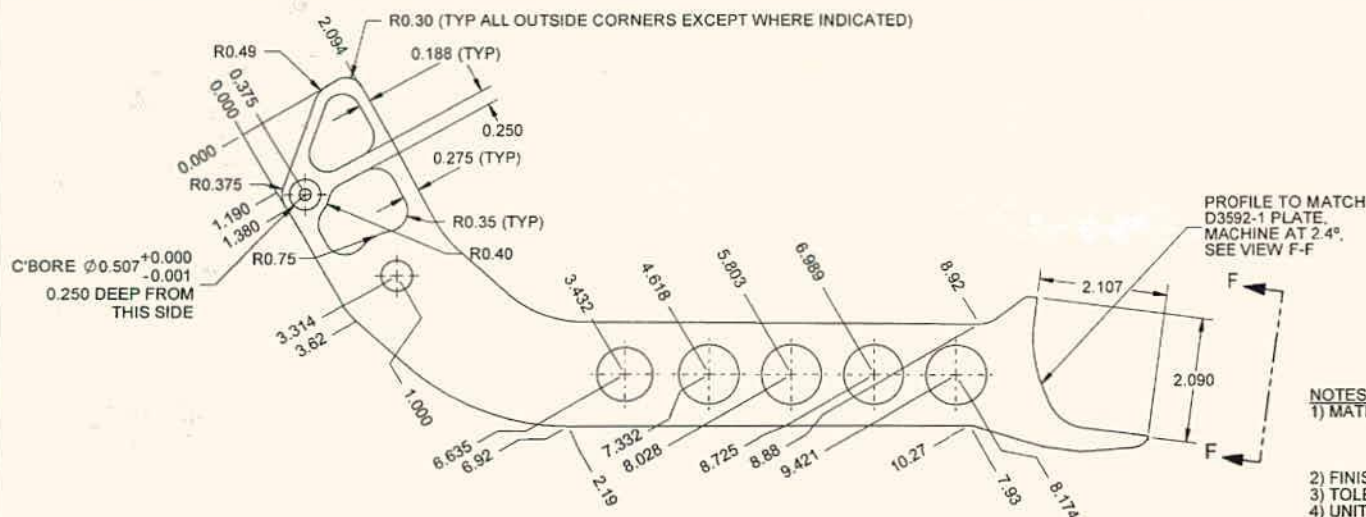
D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT. ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3560
 TITLE
ARM WELDMENT
 SCALE
 1:4

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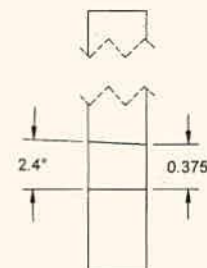
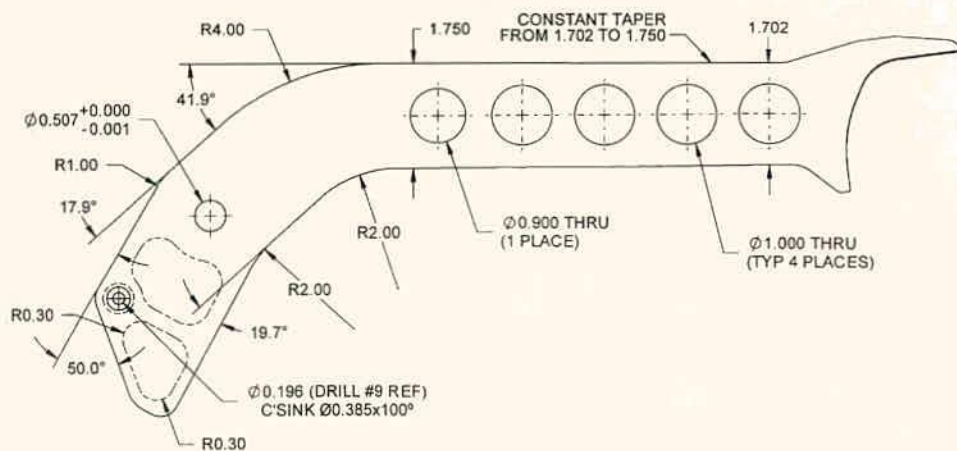
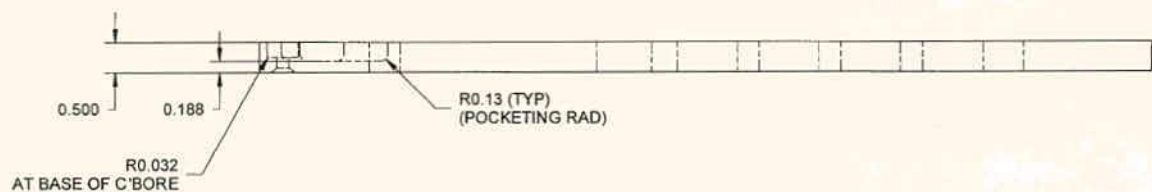




D3560-4 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3560	SHEET 5 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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